

Work Order ID 53301

October 29, 2009 2:24:45 PM



Page 1

Item ID: PB67-43001-79

Accept



Setup Start



Revision ID: C

Stop



Item Name: Lower Blade Support Assembly

Start Date: 10/30/2009 Start Qty: 2.00

MF 09-10-29



Cust Item ID:

Required Date: 11/16/2009 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: *UMF*

Date: *09-10-29* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

B67-43001

C

100

Weld per dwg A/R Aluminum rod Batch: *2112866*

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld assembly as per dwg PB67-43001

Pl 09 11 26

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

BE 2 09/11/26

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) 50211/26

(42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53301

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Page 2

Item ID: PB67-43001-79

Accept



Setup Start



Revision ID: C

Stop



Item Name: Lower Blade Support Assembly

Start Date: 10/30/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 11/16/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00



Powdercoat

Memo

M 19144

0.00

Powder Coating

*** put screws in nut plates before to keep thread clean***

START TIME:

1:00

OVEN TEMPERATURE:

320°

FINISH TIME:

1:30

BL 09-12-01

(2)

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

ML 09/12/01

X2

Ø

150

Identify as per dwg & Stock Location: *ST 444*

0.00



Packaging

Memo

0.00

Packaging

CS/12/2 (2)

W/O:		WORK ORDER CHANGES					
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Item ID: PB67-43001-79

Accept



Setup Start



Revision ID: C

Stop



Item Name: Lower Blade Support Assembly

Start Date: 10/30/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 11/16/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/03 *[Signature]*
MF 09-12-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

October 29, 2009 2:24:45 PM

Page 1

Work Order ID: 53301

Parent Item: PB67-43001-79RevC

Parent Item Name: Lower Blade Support Assembly


Comments:

Start Date: 10/30/2009

Required Date: 11/16/2009

Start Qty: 2.00

Required Qty: 7.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
PB67-43001-171RevB1		Manufactured	No			100	Each	39.0000	1.0000			
												
Mounting Plate												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

39

41563

39

PB67-43001-177RevB1

Manufactured No



Short Support Plate

100

Each

2.0000

2.0000



② 10/11/25 ✓

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

41564

2

PB67-43001-179RevB1

Manufactured No



Short Side Plate

100

Each

5.0000

4.0000



10/11/25 ✓

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5

52431

5

10/11/25 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

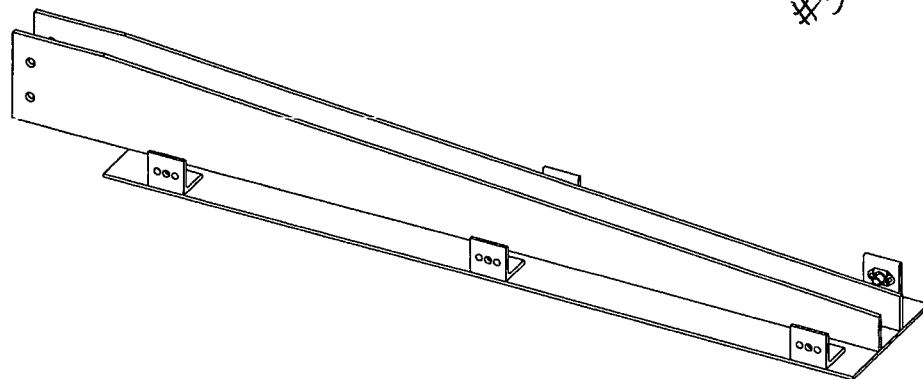
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NOTE: Date & initial all entries

#53301



B67-43001-79 LOWER BLADE SUPPORT ASSY

ITEM	QTY -79	P/N	DESCRIPTION
1	X	B67-43001-79	LOWER BLADE SUPPORT ASSY
3	6	B67-43001-171	MOUNTING PLATE
4	1	B67-43001-177	SHORT SUPPORT PLATE
5	2	B67-43001-179	SHORT SIDE PLATE
7	12	MS20426AD3-4	RIVET
8	6	MS21075L3	NUT PLATE

RELEASED
2009-09-24
MPO

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-79" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.96 lbs
- 8) WELDING: PER DART QSI 004

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 11 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	09.06.26
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		B67-43001-79	SHEET 1 OF 2
MFG. APPR.		TITLE	SCALE
APPROVED		LOWER BLADE SUPPORT ASSY	NTS
DE APPR.	N/A	COPYRIGHT © 1995 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	09.06.26		

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8

7

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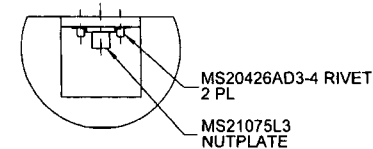
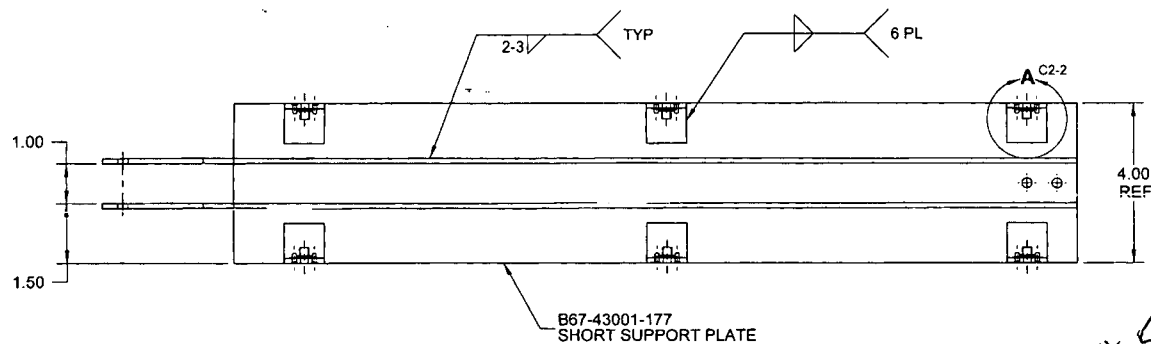
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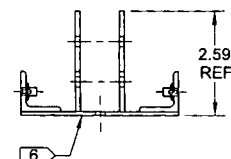
1

D

D



DETAIL A D4-2
SCALE 2X, 6 PL



B67-43001-79 LOWER BLADE SUPPORT ASSY

RELEASED
2009-09-24
MD

A

A

DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	B67-43001-79	SHEET 2 OF 2
APPROVED	MD	TITLE	SCALE
DE APPR.	N/A	LOWER BLADE SUPPORT ASSY	NTS
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8

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1

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